

Date: Tuesday, 12/5/2006 8:14:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 29773		
Estimate Number	: 10101	Part Number	: D2011101
P.O. Number	: <i>NIA</i>	Drawing Number	: D2011 REV. F
This Issue	: 12/5/2006	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: F
First Issue	: <i>NIA</i>	Material	: <i>NIA</i>
Previous Run	: 27163	Due Date	: 12/23/2006
Written By	: <i>[Signature]</i>	Qty:	50 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2639* *C20612106*

Purchase Grote Mirror P/N: 28043

Possible supplier: UAP/NAPA

Material release note required

(50)

2.0	28043	MIRROR 6"
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*LB06/12/08* (50)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

*[Signature]*  
*LB06/12/11* (50)  
*QSP09*

5.0	D30141	Locknut
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1 Lock nut *B25021*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 29773

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

M101237

SAD 06/12/21

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241adhesive per hole.

Qty Part Number Description Batch  
9ml N/A Sikaflex-291/-241

Batch  
M102107218  
02/2007

M1026722  
02/2007

SAD 06/12/21

4- Test assembly to 50lbs pull test after 24 hours

Start: 06/12/21 Time: 9:30

Finish: 07/01/16 Time: 2:50

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST198

10.0

QC21

FINAL INSPECTION/W/O RELEASE



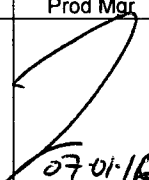
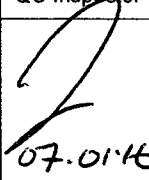
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/01/16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.16	B.O	Test ASS'Y to 50 LBS pull test. move AT Q&S perm. change.	E	07.01.16		 07.01.16	 07.01.16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/16

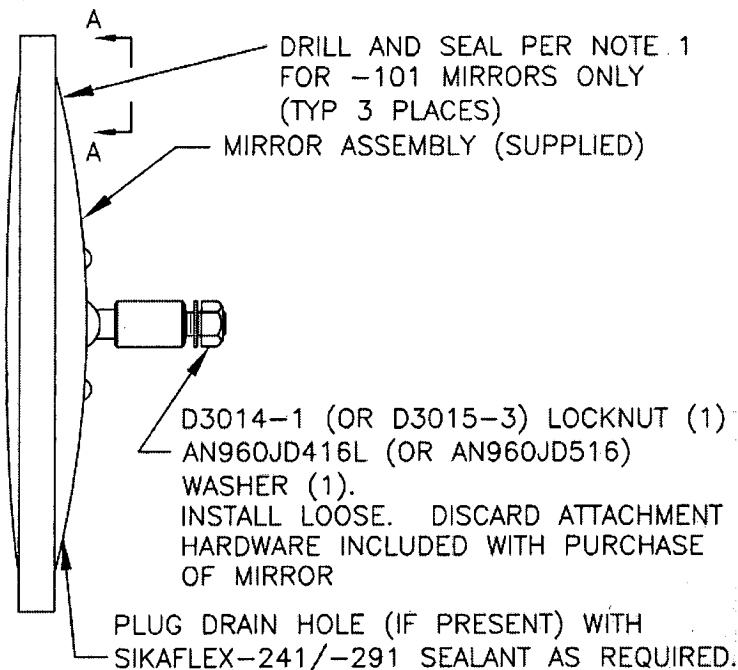
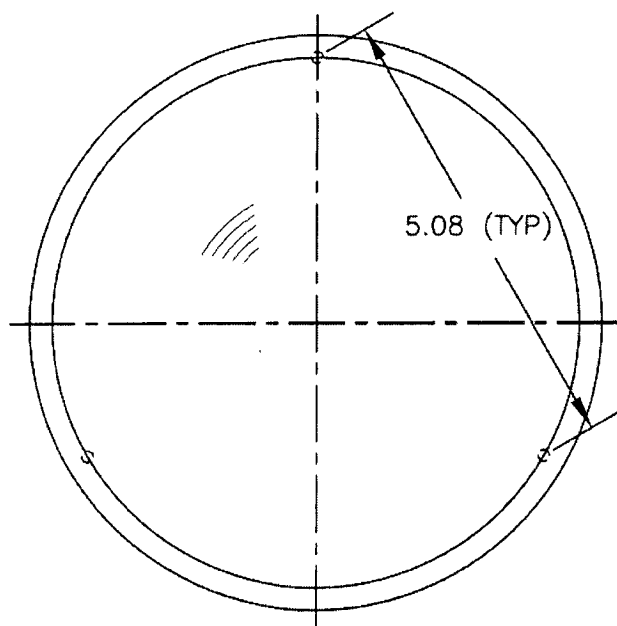
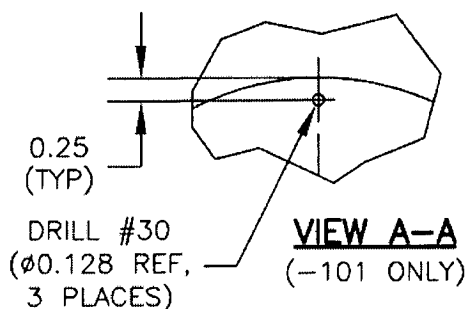
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



RELEASED  
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
1	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
	1	AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

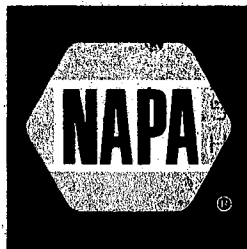
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29773

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



HAWKESBURY AUTO PARTS INC 55806ST#: 861597896RT0001  
4 MAIN STREET WEST  
HAWKESBURY, ONT. K6A 2J2  
632-8575 FAX: 632-1539

EXC#:SU 6259 EXP:03/12/31  
DANGEROUS GOODS PERMIT  
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS  
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	12/08/06	14:34	060004074	31	143492
SR #		PURCHASE ORDER #				ATTENTION
6		2639				
AD		TAX EXEMPTION: 6122-5207				
		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043	GRD	GRDTE	50.00	41.140	16.820	841.00 T150

Handwritten: 83 06/12/08

REFUNDED BY \_\_\_\_\_

VERIFIED BY \_\_\_\_\_

*Robert Haddon*  
SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

Subtotal 841.00  
Tax 6% GST ONLY 50.46  
Tax 0% 0.00

TOTAL -----> CHARGE SALE 891.46